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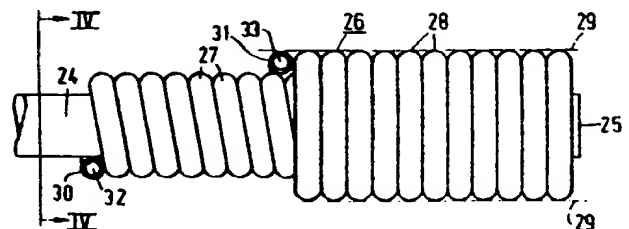
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High-pressure discharge lamp.

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The high-pressure discharge lamp has electrodes which comprise a tungsten rod (24) which projects inside the lamp vessel and around whose end (25) projecting inside the lamp vessel a tungsten wire portion (26) is helically wound. The ends (30, 31) of the helically wound wire portion (26) are located within the sheath (29) of this wire portion (26) and the end faces (32, 33) are rupture surfaces devoid of burrs.



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## High-pressure discharge lamp.

The invention relates to a high-pressure discharge lamp comprising a translucent lamp vessel, which is sealed in a vacuum-tight manner, which is filled with ionizable gas and which has electrodes which project into the lamp vessel and are connected to current supply conductors, which extend to the exterior through the wall of the lamp vessel, the electrodes each comprising a rod of mainly tungsten, around which is wound at its end projecting inside the lamp vessel a wire portion of mainly tungsten, having ends with end faces. Such a lamp is known inter alia from British Patent Application 8,331,819 (PHN 10513).

The wire helically wound around the rod of the electrode may have for its object solely to obtain a satisfactory temperature distribution over the electrode, but may also serve to hold electron-emitting material.

During the operation of helically winding the wire, the beginning part of the wire must be held, for example, in a clamp and after the operation of winding the wire has been accomplished, the wound wire portion must be separated from the remaining non-wound wire. The clamped beginning part of the wire must also be removed. The wound wire portion is freed from the non-wound beginning and end parts by clipping, pinching, grinding or cutting. Burrs are then mostly formed at the end faces of the wound wire portion. Due to the fact that the wound wire portion is freed, its ends spring out because they were deformed to a lesser extent during winding than parts remote from the ends. Moreover, it is not possible to approach the wound wire portion with the tools very closely, the less so if this wire portion must not be damaged. In high-pressure discharge lamps manufactured in

mass production, the ends of the helically wound wire portion therefore project for a considerable part beyond the sheath of the helical portion and the end faces have a burr.

5           However, projecting ends may be disadvantageous because they may form a preferential area at which the discharge arc can terminate or because upon ignition of the lamp they prevent the discharge arc from soon terminating on the tip of the electrode. They may also be  
10   disadvantageous if during manufacture of the lamp the electrodes must be slipped inside through a narrow opening of the lamp vessel.

          The invention has for its object to provide a solution for the problem of projecting ends in discharge  
15   lamps comprising rods provided with a winding and to provide lamps having electrodes of a construction that can be manufactured in a simple manner.

          According to the invention, this object is achieved in a lamp of the kind described in the opening  
20   paragraph in that the ends of the wire portion are located at least substantially within the sheath of the helically wound wire portion and in that the end faces are rupture surfaces.

          Rupture surfaces have a typical structure, by  
25   which they are distinguished from surfaces obtained by cutting, pinching, clipping or grinding. Their surface is rough and is devoid of tracks, such as grooves, which are left by tools in separation surfaces. Due to the roughness of the surface, the latter also becomes dull. Furthermore,  
30   with rupture surfaces, a burr left by tools is absent. Rupture surfaces can therefore be readily recognized by those skilled in the art.

          The helically wound wire of the electrode of the lamp according to the invention can be obtained in that,  
35   after the operation of helically winding the wire has been accomplished, the remaining part of the wire not helically wound is severed from the helically wound wire portion by

tearing off said remaining part. The wire then breaks at the area at which the wire loses the contact with the rod onto which it is wound.

The invention is based on the recognition of the fact that the force exerted on the wire during the gearing step produces a plastic deformation in the end of the wound wire portion. Deformations have also occurred during the operation of winding the wire portion between the ends of this portion. Due to this plastic deformation, upon tearing off the relevant end of the helically wound wire portion is located at least substantially within the sheath of this wire portion. The rupture surface is flat and free from burrs. At the area immediately adjoining the rupture surface, the wire portion has a smaller diameter than at areas more remote from the rupture surface. If before winding the wire portion is heated, for example at a temperature lying in the range of from 800 to 850°C, in order to straighten the wire, the diameter reduction is larger than if the wire portion has not been heated or has been heated at a lower temperature. The first end of the wire, which is held by a clamp during the operation of winding the wire portion, can be severed from the wire portion in a corresponding manner.

The rod onto which the wire portion is wound may be the electrode rod or an auxiliary rod which is separated from the wound wire portion, after which the wound wire portion is arranged to surround the electrode rod. The wire portion may be fixed on the electrode rod, for example, by a weld.

The helically wound wire portion may be disposed in several (for example two) layers around the electrode rod, a first layer of turns being directly disposed around the electrode rod and a second layer of turns surrounding the first layer. Alternatively, the helically wound wire portion around the electrode rod may be surrounded by a separate helically wound wire portion.

The lamp according to the invention may be a high-pressure sodium lamp provided with a ceramic lamp vessel of, for example, aluminium oxide or sapphire or may be a high-pressure mercury vapour discharge lamp which may contain metal halides and has a ceramic or quartz glass lamp vessel.

Embodiments of the lamp according to the invention are shown in the drawing. In the drawing :

Fig. 1 shows in developed side elevation a high-pressure sodium discharge lamp,

Fig. 2 shows in longitudinal sectional view a high-pressure mercury vapour discharge lamp,

Fig. 3 shows an electrode in side elevation,

Fig. 4 shows a diagrammatic representation of a sectional view of the electrode shown in Fig. 3 taken on the line IV-IV.

The high-pressure sodium discharge lamp shown in Fig. 1 has a translucent lamp vessel 1 of mainly aluminium oxide, which is sealed in a vacuum-tight manner and has an ionizable filling of sodium, mercury and xenon. Electrodes 2 project into the lamp vessel 1 and are connected to current supply conductors 3, which extend to the exterior through the wall of the lamp vessel. The electrodes 2 each have a rod 4 of mainly tungsten, around which at their ends 5 projecting inside the lamp vessel 1 a wire portion 6 of mainly tungsten is helically wound. The ends of the wire portion 6 are located within the sheath of the helically wound wire portion 6 and its end faces are rupture surfaces devoid of burrs. The lamp vessel 1 is mounted within an outer envelope 7, which has at one end a lamp base 8 to which the current supply conductors 3 are connected.

The high-pressure mercury vapour discharge lamp shown in Fig. 2 has a quartz glass lamp vessel 11, which is sealed in a vacuum-tight manner and has an ionizable filling of argon, mercury, sodium-, scandium- and thorium-iodide. Electrodes 12 connected to current

supply conductors 13a, 13b projecting beyond the lamp vessel 11 project into the lamp vessel 11. They have an electrode rod 14, around which at its end projecting within the lamp vessel 11 a wire portion 16 of mainly tungsten is helically wound. The ends of this wire portion 16 are located within the sheath of the helically wound wire portion 16 and its end faces are rupture surfaces devoid of burrs.

In Figures 3 and 4, the electrode rod 24 of mainly tungsten has at one end 25 a helically wound wire portion 26 of mainly tungsten. The electrode rod 24 is directly surrounded by a first layer of turns 27, whose turn lying closest to the end 25 of the rod 24 passes into the turn lying closest to this end 25 of a second layer of turns 28, which surrounds the first layer of turns 27 over a part of its length. The sheath of the helically wound wire portion 26 is denoted by reference numeral 29. The ends 30 and 31 of the wire portion 26 are located within the sheath 29. The end faces 32 and 33 are rupture surfaces devoid of burrs. The ends 30 and 31 have a diameter smaller than that of the wire portion 26 remote from those ends. The wire portion 26 is fixed on the rod 24 by means of a weld made on a turn 27.

For explanation, In Fig. 4 the beginning part 34 of the wire is indicated, from which the wire portion 26 is wound, while reference numeral 35 denotes the remaining part of this wire. During the operation of winding the wire portion 26, the beginning part 34 was fixed in a clamp. The wire portion 26 was subjected during winding to a tensile force of 0.6 N, which gave rise to a plastic deformation of the wire portion 26.

In a 30 W metal halide lamp as shown in Fig. 2, electrodes of the kind shown in Fig. 3 were used, in which the electrode rod had a diameter of 140  $\mu$ m and a wire portion having a diameter of 50  $\mu$ m was wound around this rod over a length of 1 mm. The wire portion was wound with a pitch equal to its own diameter. In the first layer, the

wire portion had twenty turns. It was wound back in a second layer over the first layer with eleven turns. The beginning part and the remaining non-wound wire were torn off with a force of 5 N, which resulted in a reduction in diameter near the rupture surfaces.

Although in this lamp the wire portion was wound with a pitch equal to its own diameter, the wire portion could have been wound with a higher pitch or over a part of its length with a higher pitch, for example in a few turns of the first layer. The wire portion and the rod contained tungsten and 1.5 % by weight of  $\text{ThO}_2$ .

1. A high-pressure discharge lamp comprising a translucent lamp vessel, which is sealed in a vacuum-tight manner, which is filled with an ionizable gas and which has electrodes which project into the lamp vessel and are connected to current supply conductors extending to the exterior through the wall of the lamp vessel, the electrodes each comprising a rod of mainly tungsten, around which at its end projecting inside the lamp vessel a wire portion of mainly tungsten is helically wound, which has ends with end faces, characterized in that the ends of the wire portion are located at least substantially within the sheath of the helically wound wire portion and in that the end faces are rupture surfaces.

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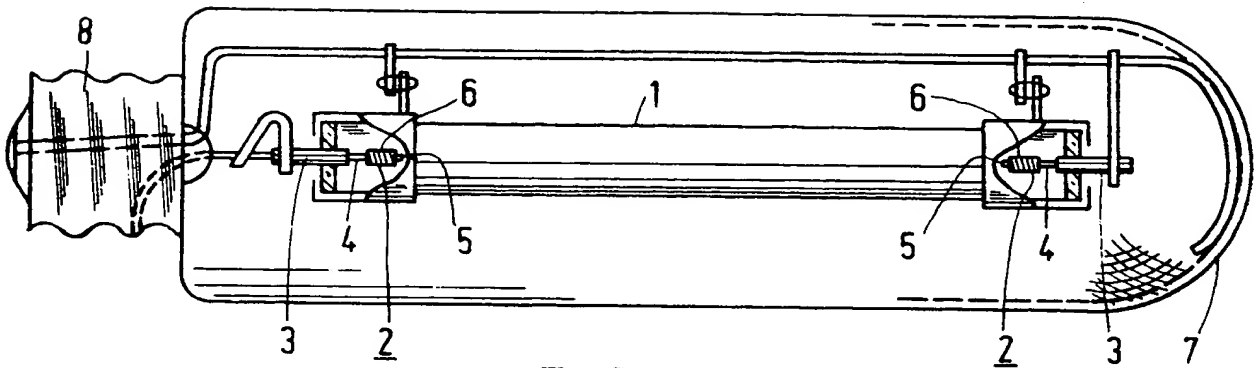


FIG. 1

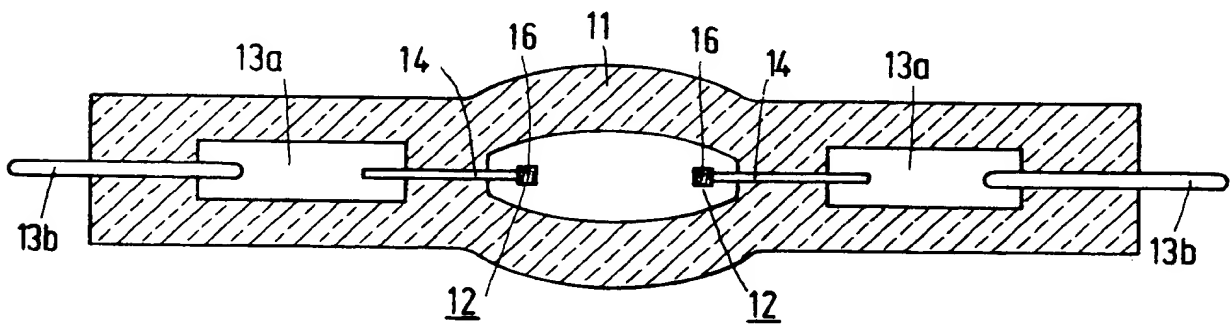


FIG. 2

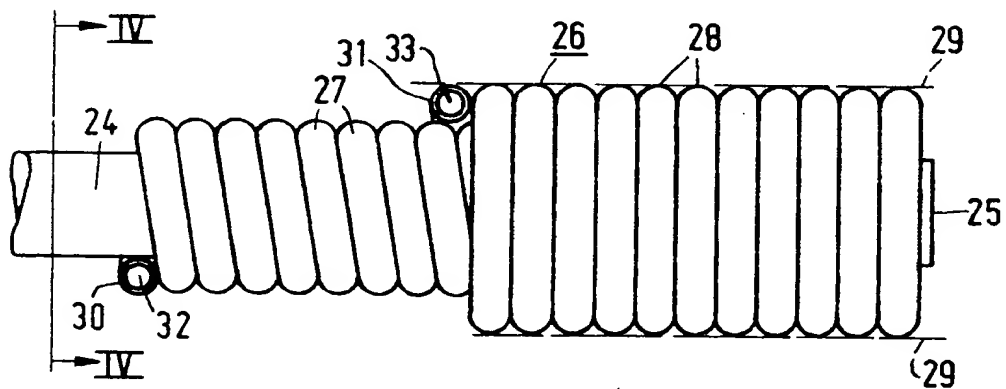


FIG. 3

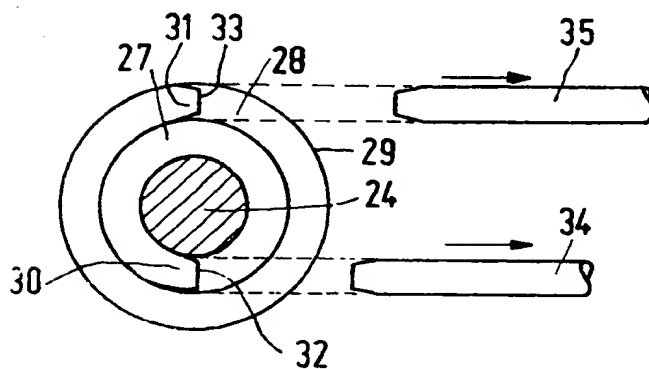


FIG. 4



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
A	PATENTS ABSTRACTS OF JAPAN, vol. 7, no. 204 (E-197)[1349], 9th September 1983; & JP-A-58 102 431 (TOKYO SHIBAURA DENKI K.K.) 18-06-1983	1	H 01 J 9/02 H 01 J 61/073
A	--- PATENTS ABSTRACTS OF JAPAN, vol. 7, no. 292 (E-219)[1437], 27th December 1983; & JP-A-58 166 629 (MATSUSHITA DENSHI KOGYO K.K.) 01-10-1983	1	
A	--- US-A-3 170 081 (F. ROKOSZ) * Column 2, line 60 - column 5, line 19; figures 1-12 * -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			H 01 J 61/00 H 01 J 9/00
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 10-10-1986	Examiner SARNEEL A.P.T.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	